

Date: Monday, 12/01/2009 11:14:16 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 L WEB		
Job Number	: 44549		Part Number	: D26547		
Estimate Number	: 10722		Drawing Number	: D2654 REV E1		
P.O. Number	:		Project Number	: N/A		
This Issue	: 12/01/2009 S.O. No. :		Drawing Revision	: E1		
Prsh Rev.	: NC		Material	:		
First Issue	: / / Type : SKIDTUBES		Due Date	: 16/01/2009 Qty: 4 Um: Each		
Previous Run	: 44231					
Written By	:					
Checked & Approved By	: JWD 09.01.12					
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM Est Rev:E 06.04.05 Added level21		EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :										
1.0	D26007140	EXT. "I BEAM" THICK										
 Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: <table border="1"> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> <tr> <td>1</td> <td>D2600-7- 140</td> <td>Web</td> <td>B41591</td> </tr> </table> 9-1-12 (4)					Qty	Part Number	Description	Batch	1	D2600-7- 140	Web	B41591
Qty	Part Number	Description	Batch									
1	D2600-7- 140	Web	B41591									
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1										
 Comment: LANDING GEAR RESOURCE 1 <p>1-Cut D2600-7 to length as per Dwg D2654 <i>a.m 09.01.12 (8)</i></p> <p>2-Drill pilot holes in web using drill jig DT 8018-7 as perDwg D2654</p> <p>3-Using the uni-bit, open holes to finish size as per Dwg D2654 <i>a.m 09-01-12</i></p> <p>4-Deburr holes and ends</p>												

3.0	QC5	INSPECT WORK TO CURRENT STEP		
 Comment: INSPECT WORK TO CURRENT STEP <i>9-1-12 (1)</i>				

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1		
 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>Au m 9-1-12 (4)</i>				

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



9-1-12

(4)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: shed tube

9-1-12

(4)

7.0 QC21 FINAL INSPECTION/W/O RELEASE



09/01/14 AJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-13

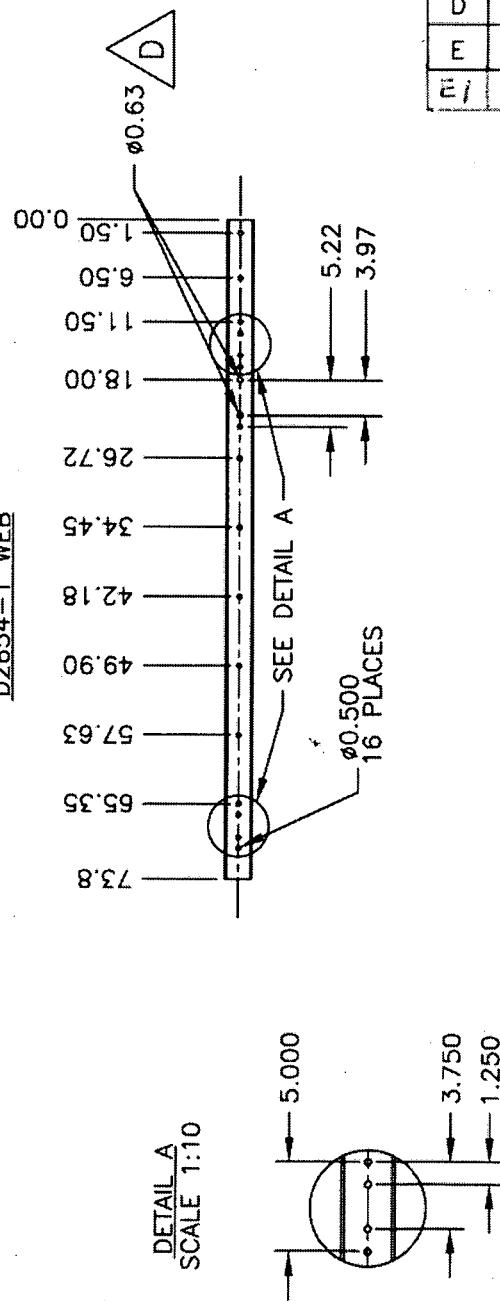
DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654 REV. E SHEET 1 OF 2
DATE		TITLE WEB
04.05.26		SCALE 1:20

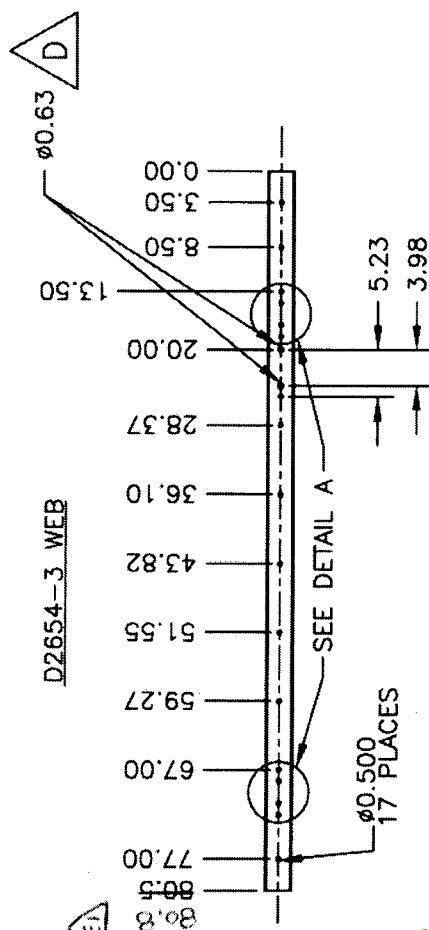
RELEASED

04.06.22

D2654-1 WEB



D2654-3 WEB



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MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

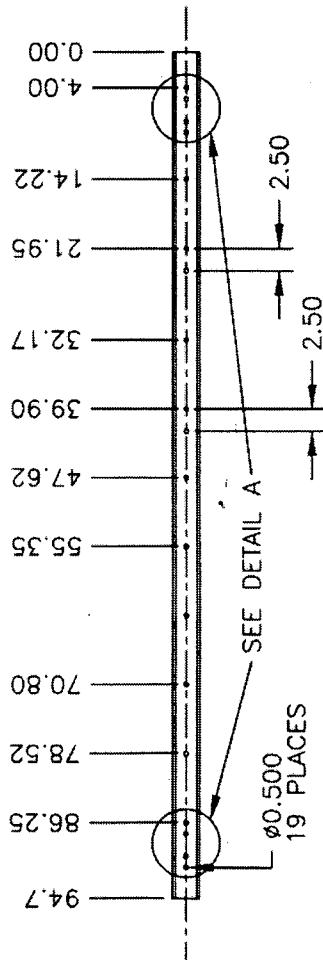


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CHECKED	APPROVED	DRAWING NO. D2654
DATE		REV. E SHEET 2 OF 2

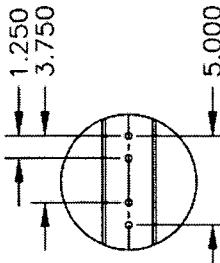
04.05.26 TITLE SCALE
WEB 1:20

RELEASED
04.05.26

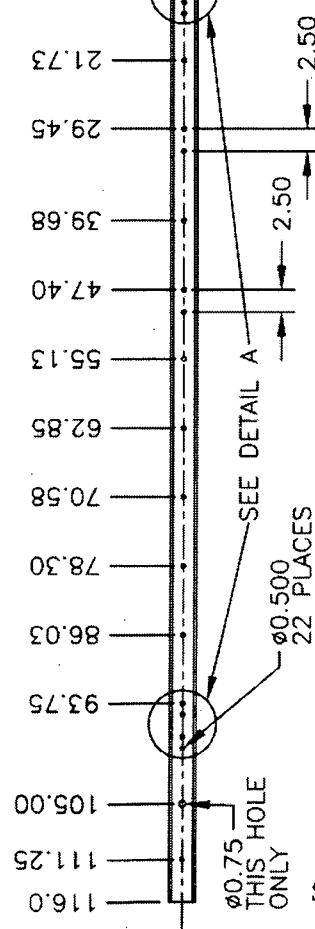
D2654-5 WEB



DETAIL A
SCALE 1:10



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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